

Date:
User:Wednesday, 1/18/2006 4:11:03 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ALUMINUM BILLET RD
Job Number	: 25572		
Estimate Number	: 11109		
P.O. Number	: N/A	Part Number	: D6103001
This Issue	: 1/18/2006 S.O. No. : N/A	Drawing Number	: D6103 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 2/5/2006 Qty: 30 Um: Each
Checked & Approved By	: <u>SEE ABOVE USER</u>		
Comment	: Est Rev:A 01.05.08 New Issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 00000412 06/01/19

a) Description: Alluminum round billet

b) Ø3.250" x 12.500" long

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 7075-T6/T651 (QQ-A-200/11 or QQ-A-225/9)

Material certification required

2.0 D6103001 7075-T651 3.25OD x 12.5L

Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)
7075-T651 3.25OD x 12.5L

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for transit damage Ensure certification are attached

C206/01/26(30)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

BG 06.02.2730

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C206/02/2230

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/02/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:11:03 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ALUMINUM BILLET RD

Job Number: 25572

Part Number: D6103001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

060223 (30)

Job Completion



6 06-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

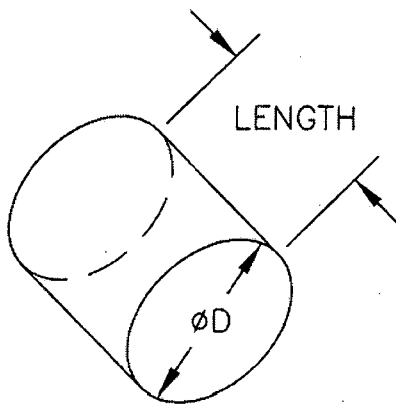
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6103	Rev. A SHEET 1 OF 1
DATE 01.04.10		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01 04 23



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50

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WITHOUT NOTICE
WORK ORDER

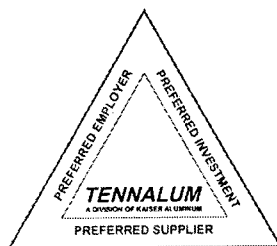
NO. 25572

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KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://KaiserEngProd.com>

CUSTOMER PO NUMBER: CE5253		CUSTOMER PART NUMBER: 024375		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 602832	LINE ITEM: 1	SHIP DATE: 05/23/2005	ALLOY: 7075	TEMPER: T651	
WEIGHT SHIPPED: 4219 lbs.	QUANTITY: 30 pcs.	B/L NUMBER: 23147	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: Copper & Brass Sales, Inc. 6905 Kenderry Gate, Unit 4 Mississauga, ON L5T 2Y8 Canada			SOLD TO: Copper & Brass Sales Inc Attn: Accounts Payable P. O. Box 5116 Southfield, MI 48086-5116 USA		

Test Code: 1000

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %
20065962	80.0	72.5	16.0
20067674	80.4	72.6	17.0

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
Min			1.2		2.1	0.18	5.1			

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4123G, AMS-QQ-A-225/9

Miscellaneous Notes

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T6 temper, AMS 4122J and QQ-A-225/9E (CANCELLED).

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 52860

Kaiser Order Number: 602832